

SPUT

Work Order ID 61882-1

PRELIMINARY ISSUE



Page 1

Wednesday, September 08, 2010 3:27:30 PM

Item ID: D4174-3

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Connector Plate Doubler

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: PADate: 10-9-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4174	PA1								
100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
	Memo								
	1-Cut as per Dwg								
	Dwg Rev: <u>PA1</u>								
	Prog Rev: <u>PA1</u>								
	2-Deburr if necessary								
110		0.00							
QC		0.00							
Quality Control									
	Memo								
	QC2- Inspect parts off machine FAI/FAIB								

10-9-13

4

10-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61882

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Page 2

Item ID: D4174-3

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Revision ID: PRELIM

Stop



Item Name: Connector Plate Doubler

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

- inspect to PM

dry only

Sidolal3



0.00

QC

Memo

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-9-14

0.00

HandFinish

Memo

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BR 10-9-16

0.00

Powdercoat

Memo

Powder Coating

Start Time: 1:50

Oven Temperature: 320°

Finish Time: 2:20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 61882



Page 3

Wednesday, September 08, 2010 3:27:30 PM

Item ID:	D4174-3	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Connector Plate Doubler					
Start Date:	9/8/2010	Start Qty:	3.00		Cust Item ID:	
Required Date:	9/13/2010	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		→ JH 10/09/16		4	Φ		
160 Packaging Packaging	Identify as per dwg & Stock Location: CA Memo J2n	0.00 0.00				85	10 09 23	Ⓚ	
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/09/29 J

POSITIVE RECALL

EFFECTIVE 10/09/09 AUTH J

RELEASED J DATE 10/09/29

10/09/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 08, 2010 3:27:34 PM

Page 1

Work Order ID: 61882



Parent Item: D4174-3



Parent Item Name: Connector Plate Doubler



Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063  6061-T6 .063 Sheet		Purchased	No			100	sf	104.9340	0.11	0.347368		.45	
												B10-9-B	

Location

Loc Qty

Loc Code

MAT21

104.934

113608

104.934

113608

B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

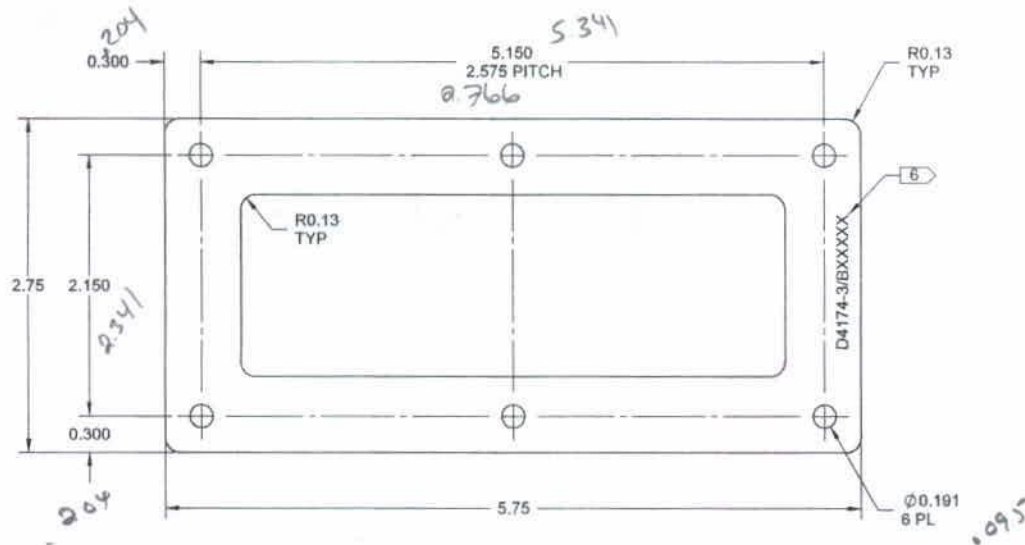
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Route / Bom / Axf
DOWE



D4174-3 CONNECTOR PLATE DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41882

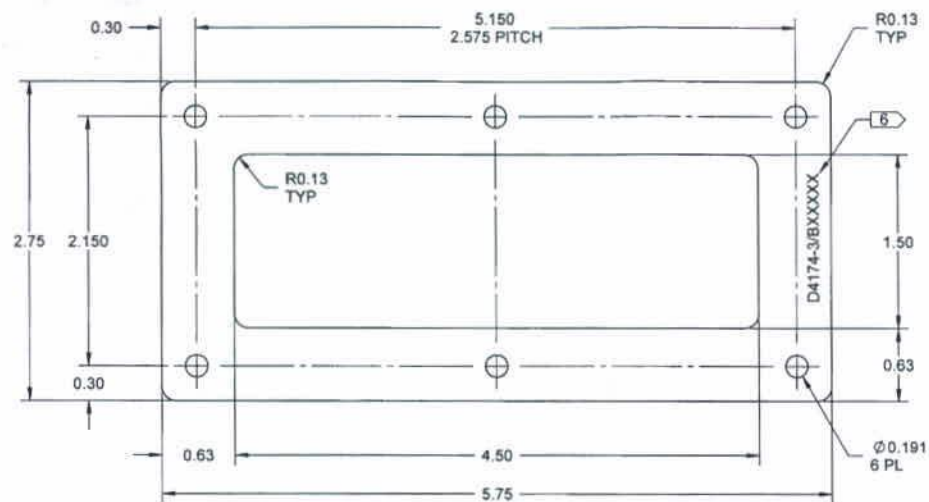
PSO-9-09

PRELIMINARY ISSUE
10.09.08

NOTES:

- 1) MATERIAL: 6061-T81/T82 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.08 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4174	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CONNECTOR PLATE	
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D4174-3 CONNECTOR PLATE DOUBLER

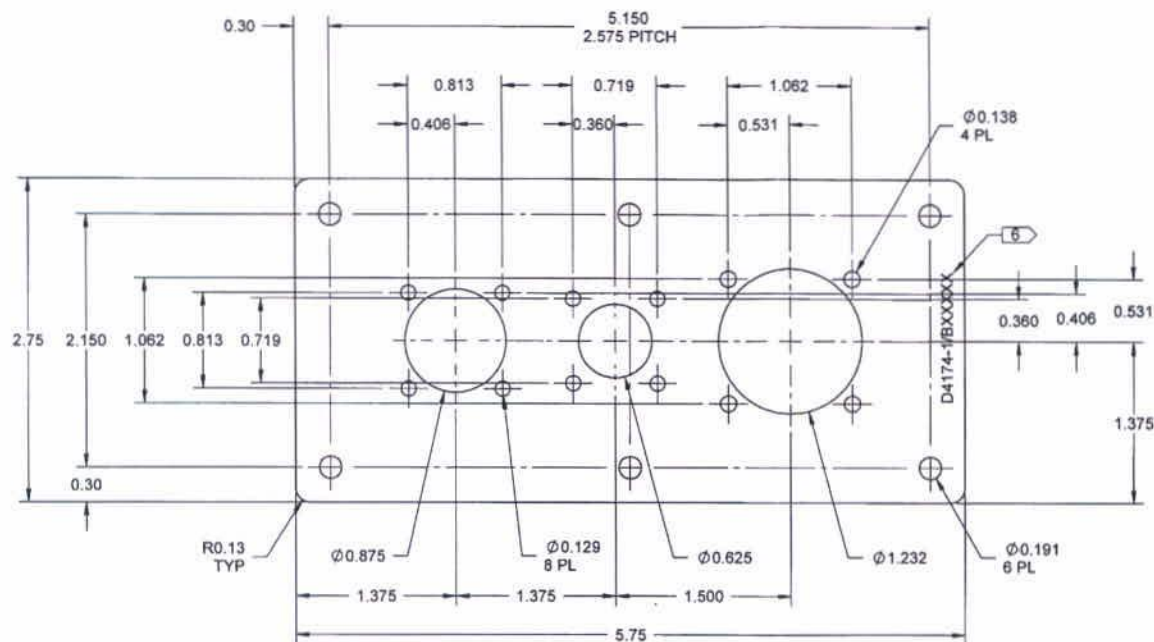
NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063
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DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4174	SHEET 2 OF 2
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DE APPR.		CONNECTOR PLATE	NTS
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RELEASED
2010-09-29
MP

61882



D4174-1 CONNECTOR PLATE

RELEASED
2010-09-28

NOTES:

- 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M5061T6S.063
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REV.	NEW ISSUE	DESCRIPTION	MB	10.09.01
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.09.01			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4174** REV. A
SHEET 1 OF 2
TITLE **CONNECTOR PLATE** SCALE NTS

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